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CHROME PLATED PARTS AND  
CHROME PLATING METHOD

ABSTRACT OF THE DISCLOSURE

Using a chrome plating bath containing organic  
5 sulfonic acid, plating is conducted by application of a  
pulse current to thereby form a crack-free lower chrome  
layer on a steel substrate. The lower chrome layer has a  
compressive residual stress of 100 MPa or more and a crystal  
grain size of from 9nm to less than 16 nm. Subsequently, by  
10 application of a direct current, a cracked upper chrome  
layer is formed on the lower chrome layer, to thereby obtain  
a chrome plated part. The lower chrome layer imparts the  
chrome plated part with heat resistance and corrosion  
resistance, and the upper chrome layer imparts the chrome  
15 plated part with wear resistance and good sliding properties.

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